USER'S MANUAL

Parameter Setting

This manual describes various parameters.

[Important]

About parameter display on the operation panel
All parameters are explained in this chapter. However, some parameters, which could affect embroidery quality if they are changed easily, are set to be hidden at shipment and they cannot be changed.
To display or change these parameters, you must enter the password and change the functional limit level.
For details of the password, consult the distributor.

TMEZ-KC

M-EZKC-PRA01-EN

Foreword

Thank you for purchasing the TAJIMA embroidery machine.
Please read this manual thoroughly, understand the contents, and then use the machine.
This manual may contain discrepancies in detailed specifications when compared with the actual product. If you have any question, please ask the distributor for information.

Purpose of This Document

This manual and other documents contain the following information. Refer to the necessary documents depending on the application and purpose. The user's manual and other documents are stored as PDF files on the supplied CD.

■USER'S MANUAL

For Safe Use	This manual contains instructions on using the machine safely. Make sure to read the manual before use.
Basics	This manual describes the basic knowledge and procedures that are common to all the models and required to use the machine. If you are a novice to or unfamiliar with the machine, be sure to read this manual first.
Basic Operation	This manual describes the basic procedures for operating the machine, performing embroidery, and performing maintenance.
Advanced Operation	This manual describes the procedures for using advanced machine functions and operations for users familiarized with basic operations.
Parameter Setting (this document)	This manual describes various parameters.
Frame Change	This manual describes how to change the frames. This does not come with some models.
Various Documents	Electrical system diagrams and other technical documents.

■Other manuals

Quick Guide	This sheet is the Quick reference regarding embroidery methods as well as frequently used functions and their operation procedures. Keep the Quick Guide handy so that you can reference it quickly.
Optional Device	This manual describes how to set up, operate, and maintain various optional devices.

Safety Precautions and Symbols

Items that require your special attention on handling the machine are specified below.

Description	Meaning
⚠ DANGER	Indicates that there is a lot of danger of death or serious injuries[*1].
⚠ WARNING	Indicates that there is a likelihood of death or serious injuries[*1].
⚠ CAUTION	Indicates a potentially hazardous situation which may result in minor or moderate injury[*2] or physical damage.

*1: A condition caused by electric shock, injury, fracture of a bone etc. that leads to aftereffects, or an injury that necessitates hospitalization or visits to a hospital over a long period.
*2: An injury that does not necessitate hospitalization or visit to a hospital over a long period.

The symbols used throughout this document have the following meanings.

Symbol	Meaning
	Item to be prohibited
	Items that may cause electric shock if not observed
	Items to keep safety

Other Precautions

Description	Meaning
	Items that may affect sewing if not observed.
	Recommended and useful tips.

Disclaimer, etc.

- The external views and specifications of the machine and the contents of this manual are subject to change without notice due to improvement.
- The screen captures and figures contained in this manual may differ depending on the machine specifications, the number of heads or needles, and the presence of optional device.
- TAJIMA bears no responsibility regarding any damage arising from not observing the instructions in the manual or any fault or damage resulting from repair, disassembly, or modification not indicated in the manual.
- You may not copy, reproduce, or transcribe a part or whole of this manual without consent of TAJIMA.

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About Functional Limit

To prevent unnecessary export of design and incorrect parameter settings, functional limit levels are used to restrict the use of particular functions.
The following functions are restricted at each functional limit level.

Functional limit level	Limit contents
	No limit • All parameters are displayed • All functions are enabled • Parameter display is freely selectable
	• Only certain parameters (pages P1 to P6) are displayed *1 • Saving designs in the USB memory • Editing designs in the machine memory (Insertion of stitch, deletion of stitch, modification of stitch) • Detailed setting at needle bar unit (Satin stitch (area), Satin stitch (density), Satin stitch (expansion))
	• All parameters except for “2. Functional limit level” on the page P8 are hidden • Saving designs in the USB memory • Editing designs in the machine memory (Insertion of stitch, deletion of stitch, modification of stitch) • Detailed setting at needle bar unit (Satin stitch (area), Satin stitch (density), Satin stitch (expansion))

*1: Press P6 twice to display “2. Functional limit level” on the page P8.

- The functional limit level is set to at shipment. Changing the functional limit level requires you to enter the password. For details, consult the distributor.

Chapter 1
Displaying and Setting Parameters

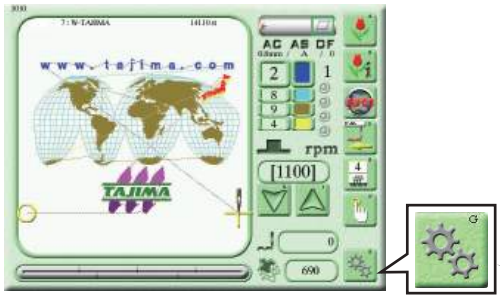
1. Switching Parameter Screens

The parameters are categorized based on their content and purposes on pages P1 to P8 of the parameter screen. To change the setting of a parameter, move to the parameter screen and open the desired page using the icons displayed at the bottom of the parameter screen.

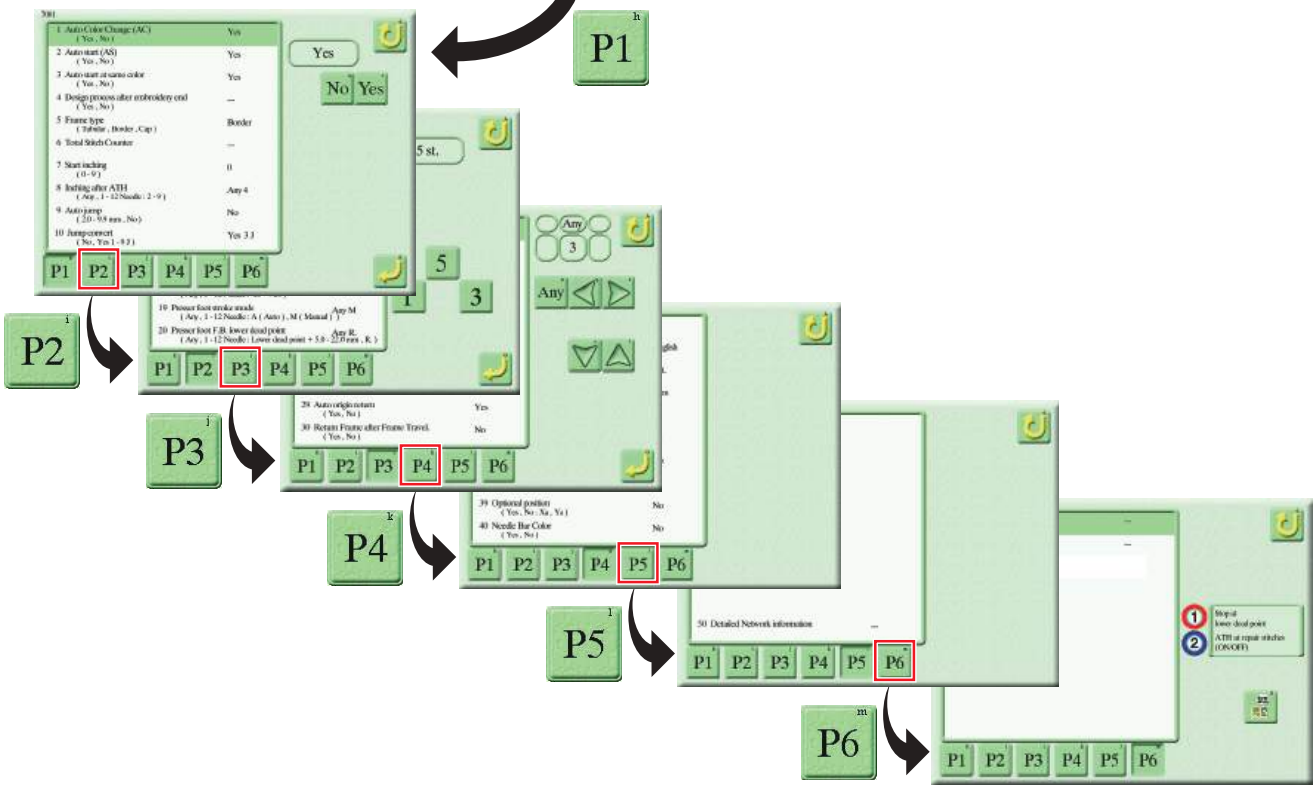
- To display pages P7 and P8, you must enter the password and change the functional limit level.

Displaying pages P1 to P6

Main screen

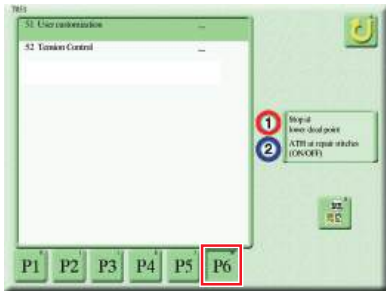


Parameter screen pages P1 to P6



Displaying pages P7 and P8

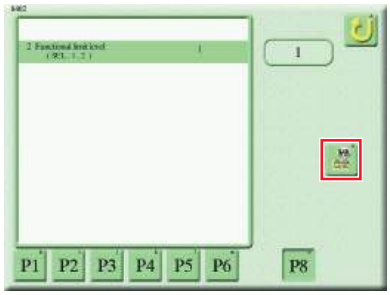
[Page P6]



- To move out of the screen other than page P6, press

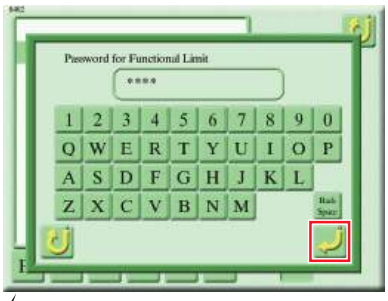
twice.

[Page P8]



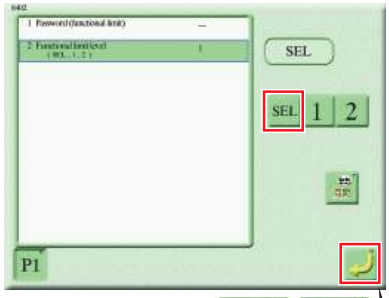
Change the functional limit level

[P8: Password]



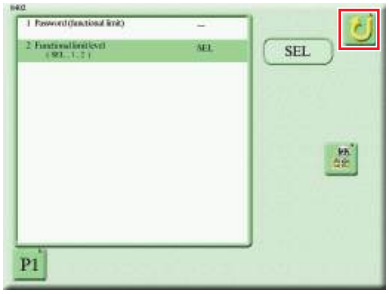
Input a password

[P8: Functional Limit Level]



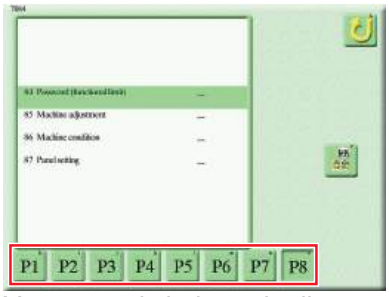
Change the level

[P8: Functional Limit Level]



Return

[P8: Functional Limit Level]



You can switch through all pages

2. Displaying/Hiding Parameters

You can display parameters in one of the following four modes:

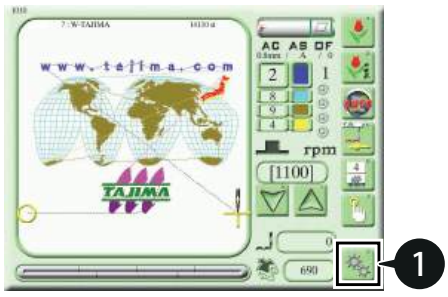
- Hide all parameters
- Display only certain parameters
- Hide only certain parameters
- All parameters are displayed

Also, you can display/hide each parameter item.

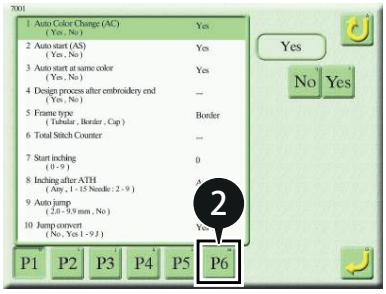
To change the parameter display mode, take the following procedure and switch to the functional limit level screen.

2-1. Switching to the functional limit level screen

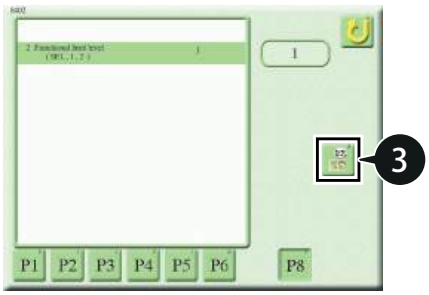
- The functional limit level is set to 1 at shipment. Changing the functional limit level requires you to enter the password. For details, consult the distributor.



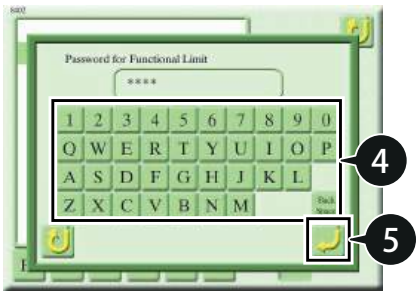
1 Press on the main screen.



2 Press twice.



3 Press .

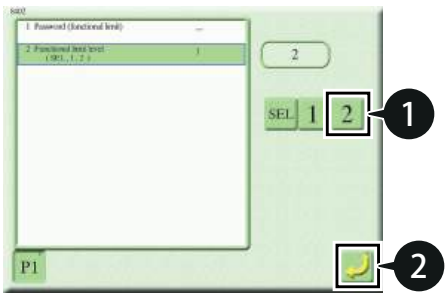


4 Input a password.

5 Press .

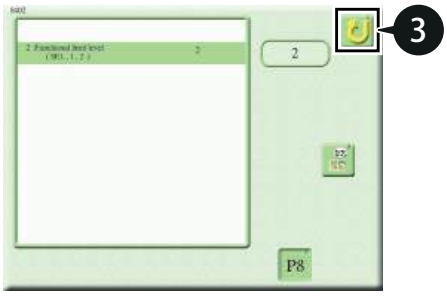
The functional limit level screen appears.

2-2. Hiding all parameters



1 On the functional limit level screen, press .

2 Press .

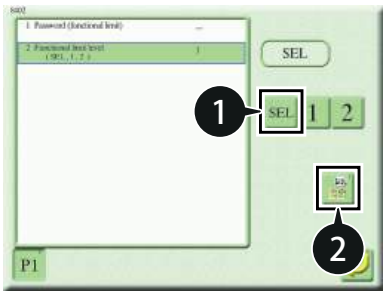


3 Press .

The functional limit level changes to “2” and all the parameters are hidden. However, “2. Functional limit level” on the page P8 is displayed.

2-3. Displaying only certain parameters

This example shows how to display only “1. Auto Color Change (AC)” and “2. Auto start (AS)”.



1 On the functional limit level screen, press .

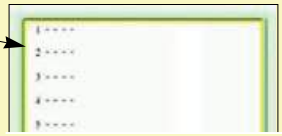
2 Press .

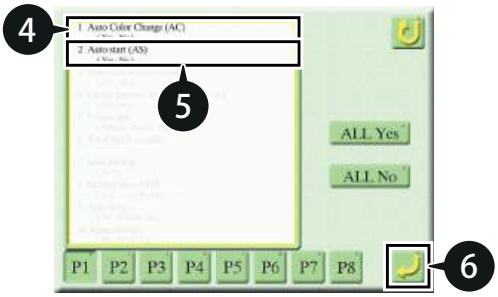
3 Press ALL No .

This hides all the parameters.

- Outer frame turns yellow when you set the functional limit level “SEL”.

Yellow

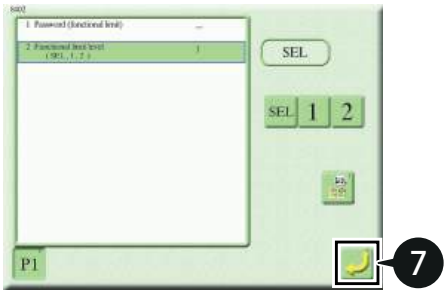




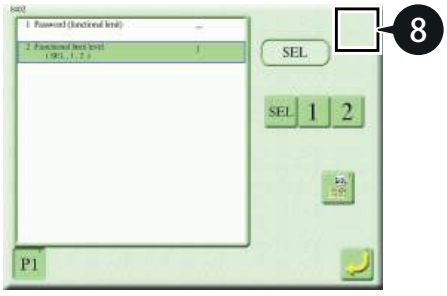
4 Select “1. Auto Color Change (AC)”.

5 Select “2. Auto start (AS)”.

6 Press .



7 Press .



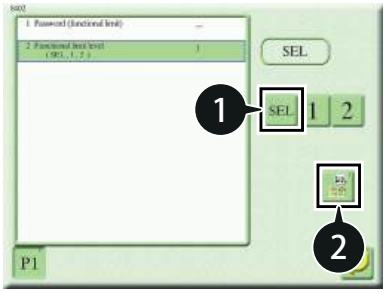
8 Press .

This displays only “1. Auto Color Change (AC)” and “2. Auto start (AS)”.

- “2. Auto start (AS)” is displayed only when “1. Auto Color Change (AC)” is set to “Yes”.

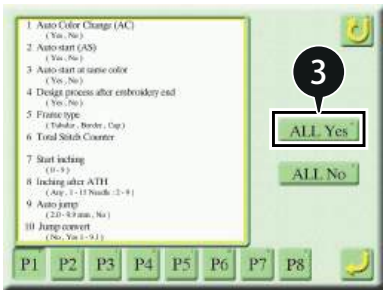
2-4. Hiding only certain parameters

This example shows how to hide only “9. Auto jump” and “10. Jump convert”.



1 Press SEL .

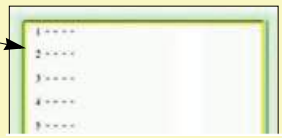
2 Press .

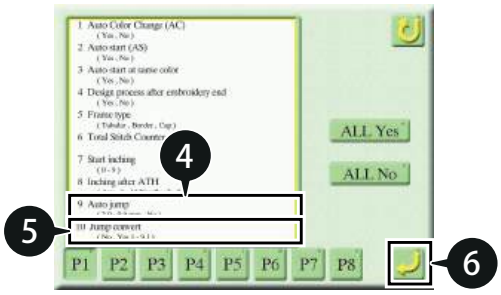


3 Press ALL Yes .

- Outer frame turns yellow when you set the functional limit level “SEL”.

Yellow

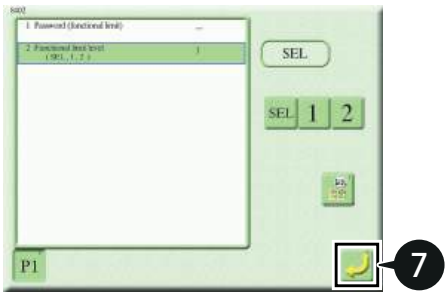




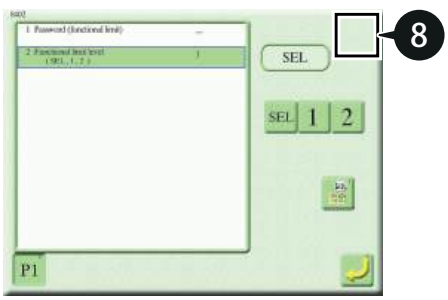
4 Select “9. Auto jump”.

5 Select “10 .Jump convert”.

6 Press .



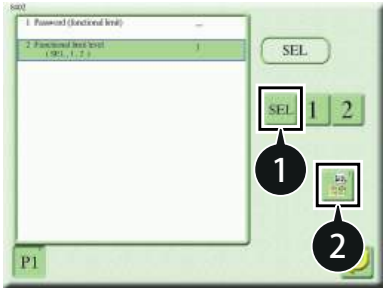
7 Press .



8 Press .

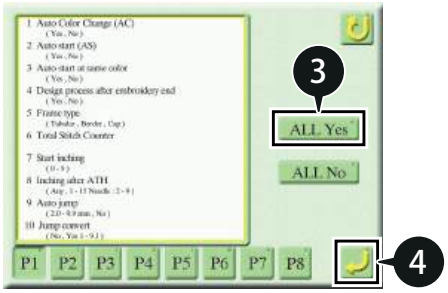
This hides only “9. Auto jump” and “10. Jump convert”.

2-5. Displaying all parameters



1 On the functional limit level screen, press SEL .

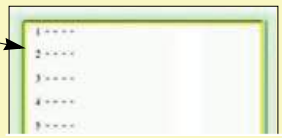
2 Press .



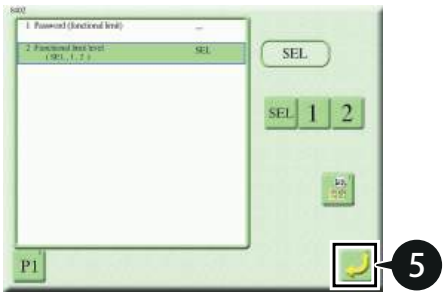
3 Press ALL Yes .

- Outer frame turns yellow when you set the functional limit level “SEL”.

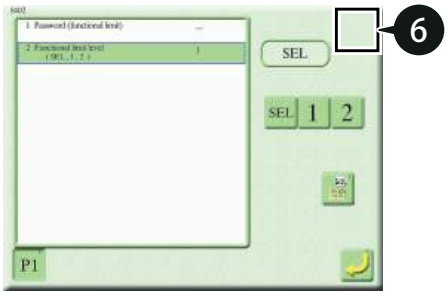
Yellow



4 Press .



5 Press .

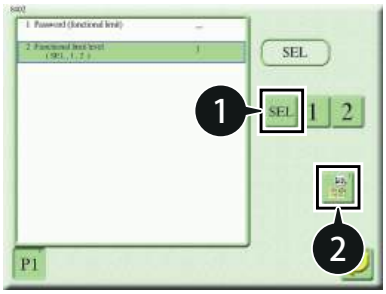


6 Press .

The functional limit level is deselected and all the parameters are displayed.

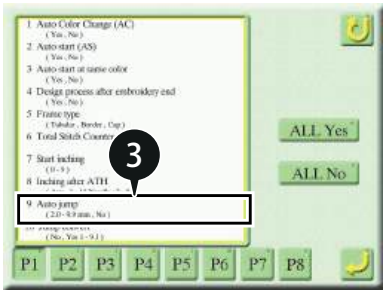
2-6. Displaying/hiding each parameter item

This example shows how to hide “9. Auto jump” and “11. F.B./F.F. stitch unit”.

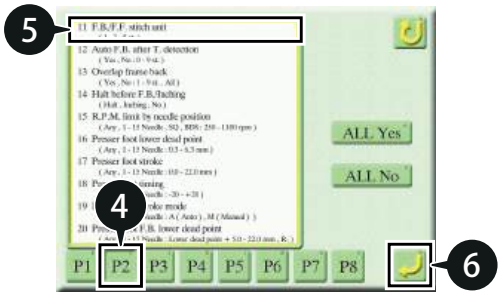


1 Press SEL .

2 Press .



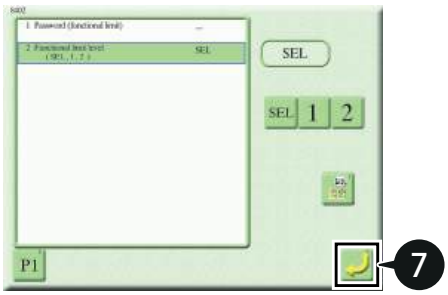
3 Select “9. Auto jump”.



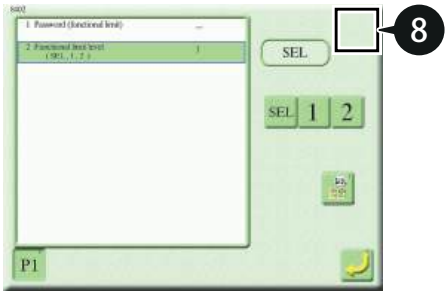
4 Press P2 .

5 Select “11. F.B./F.F. stitch unit”.

6 Press .



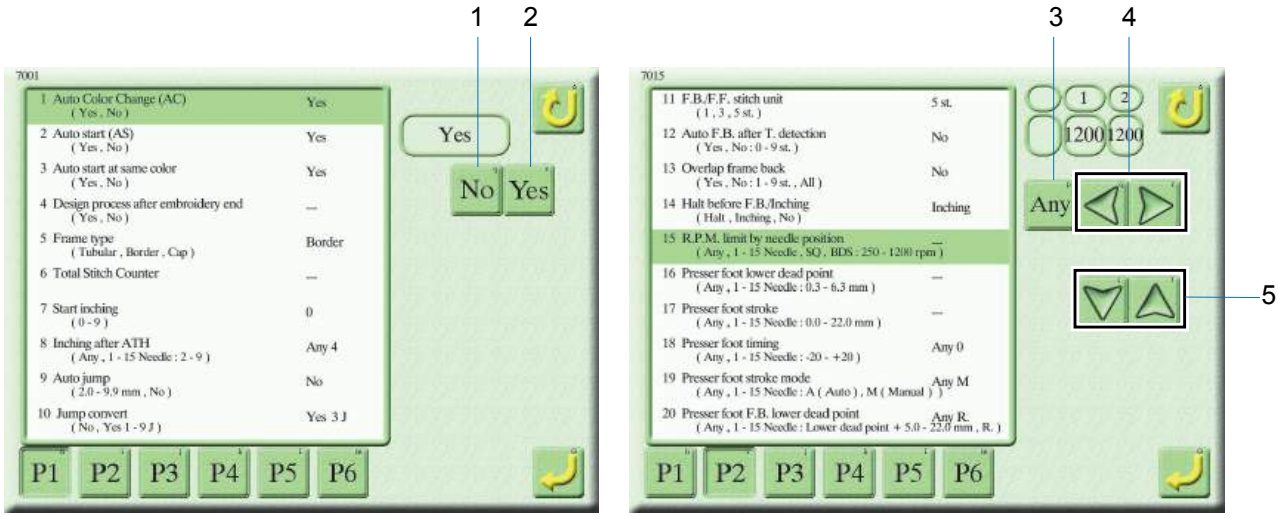
7 Press .



8 Press .

This hides “9. Auto jump” and “11. F.B./F.F. stitch unit”.

3. Basic Setting Methods



No.	Description
1	Disable the parameter.
2	Enable the parameter.
3	Configure all the needles at once.
4	Configure the setting for each needle bar (by selecting the desired needle bar No.).
5	Select one of the default choices.

Chapter 2
Parameter Items (Page P1)

1. Auto Color Change (AC)

This is the setting to change the color automatically according to “Color change sequence”.

Setting range

“Yes”: Automatically change color.
“No”: Do not automatically change color.

2. Auto start (AS)

This is the setting to start the operation automatically after color change.

Setting range

“Yes”: Auto start is performed.
“No”: Auto start is not performed.

3. Auto start at same color

This is the setting to start the operation automatically even if the same needle bar is selected before and after color change.

Setting range

“Yes”: Auto start is performed.
“No”: Auto start is not performed.

- If “No” is selected, the machine will stop when the same needle bar is selected before and after color change. Therefore, it is effective for applique embroidery.

4. Design process after embroidery end

⚠Caution

Do not put your hands or anything else on the table after embroidery. You may get injured when the machine automatically starts.

This is the setting to perform automatic start after finishing embroidery and embroider the same design repeatedly.

Setting range

■ [Auto data set]
“Yes”: Data is set automatically after embroidery end
“No”: Data is not set automatically after embroidery end

"Auto start" will be displayed if you set the "Auto data set" to "Yes", and "Data deletion" will be displayed if you set it to "No".

■ [Auto start]
“Yes”: Auto start is performed after embroidery end
“No”: Auto start is not performed after embroidery end

- This function is effective in such a case as when changing frames in sequence like socks embroidery, etc. Usually select “No” for the automatic start.

■ [Data deletion]
"Yes": The data-set design is automatically deleted on completion of embroidery.
"No": The data-set design remains after completion of embroidery.

5. Frame Type, FS mode

Set the frame type and the FS mode to use.

Setting range

“Type of frame”
Tubular goods frame, Border frame, Cap frame
[FS mode]
"Yes": The FS mode is set.
"No": The FS mode is not set.

6. Total Stitch Counter

This counter displays the embroidery time, the number of stitches, the number of designs embroidered from start of operation to now, and remaining amount until Preset Halt.

7. Start inching

Set how many times inching is performed when the operation starts again after stopping the machine during embroidery.

Setting range

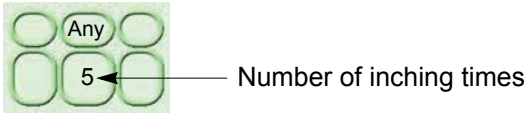
0 to 9 times

8. Inching after ATH

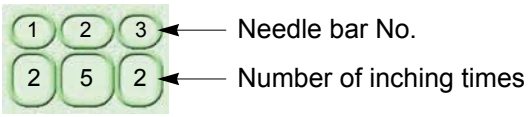
Set how many times inching is performed for all needles or a particular needle bar when the operation starts again after data setting or thread trimming.

Setting range

“Any” (all needles in a batch): 2 to 9



“Needle bar unit”: 2 to 9



9. Auto jump

This is the setting to jump automatically when the stitch length is longer than the set value. There are two types of auto jumps: A (split auto jump) and B (batch auto jump)
When the setting of Auto jump has been changed by “Step unit setting” individually, the value of “Step unit setting will take the priority.

Setting range

“No”: Auto jump is not performed.
2.0 to 9.9 mm: Auto jump is performed.

10. Jump convert

This is the setting to trim thread and move the frame to next stitch when jump codes continue more than the set times.

- If the setting of Auto jump has been changed by “Needle bar setting” individually, the value of “Needle bar setting” will take priority.

Setting range

“Yes”: Jump convert is performed. (1 to 9 times)
“No”: Jump convert is not performed.

Chapter 3
Parameter Items (Page P2)

11. F.B./F.F. stitch unit

Set frame feed amount when performing Frame back or Frame forward by 11 stitches or more.

Setting range

1, 3, 5 (stitches)

12. Auto F.B. after T. detection

This is the setting to perform Frame back automatically at thread breakage.

Setting range

“Yes”: Auto F.B. is performed.
The number of stitches to perform Frame back is as follows with reference the frame stop position.
Upper thread breakage: Sum of this value and the value shown on page P3 “26. Upper thread detection”.
Under thread breakage: Sum of this value and the value shown on page P3 “27. Under thread detection” (unit).
“No”: Auto F.B. is not performed.

13. Overlap frame back

Set a start position of embroidering at head after Frame back.

Setting range

“Yes”: Start embroidery.
If “Yes” is selected, set Head Sewing Start Point.
1: Start embroidering from the position that is one stitch prior to the start position of Frame back.
2: Start embroidering from the position that is two stitches prior to the start position of Frame back.
3 to 9: Start embroidering from the position that is 3 to 9 stitches prior to the start position of Frame back.
Whole area: Embroider at whole area of Frame back section.
“No”: Overlap frame back embroidering is not performed.

14. Halt before F.B./Inching

Set a method to start embroidering after Frame back.

Setting range

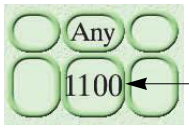
“Inching”: Lower to the start inching r.p.m.
“Halt”: Halt at the position to start embroidering.
“No”: Do not halt.

15. R.P.M. limit by needle position

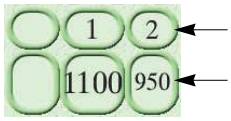
Set Maximum RPM by all needles in a batch or by needle bar unit.

Setting range

“Any” (all needles in a batch): 250 to 1100



“Needle bar unit”: 250 to 1100



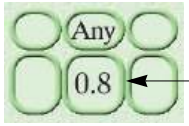
16. Presser foot lower dead point

Set the height of the lower dead point of the presser foot by all needles in a batch or by needle bar unit.

- If the setting of Presser foot lower dead point has been changed by “Needle bar setting” individually, the value of “Needle bar setting” will take priority.

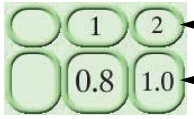
Setting range

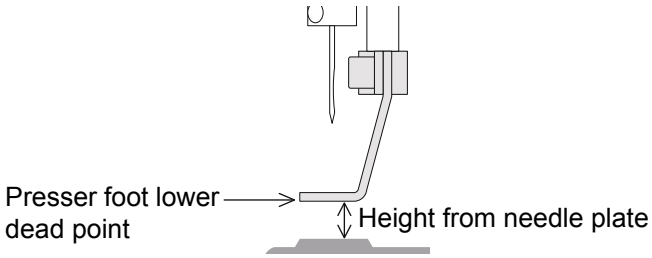
“Any” (all needles in a batch): 0.3 to 6.3 mm



“Needle bar unit”: 0.3 to 6.3 mm

Multi code needle: 0.3 to 5.3 mm





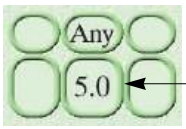
17. Presser foot stroke

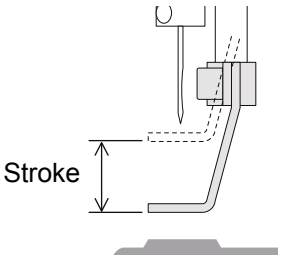
Set the height of the presser foot stroke by all needles in a batch or by needle bar unit.

- If the setting of Presser foot stroke has been changed by “Needle bar setting” individually, the value of “Needle bar setting” will take priority.

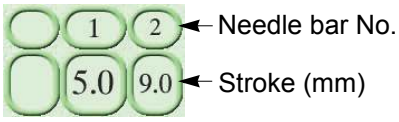
Setting range

“Any” (all needles in a batch): Functional limit level 1: 5.0 to 22.0 mm
Functional limit SEL: 2.0 to 22.0 mm





“Needle bar unit”: Function limit level 1: 5.0 to 22.0 mm
Functional limit SEL: 2.0 to 22.0 mm
Multi code needle: 0.0 to 22.0 mm



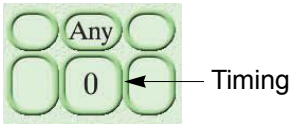
18. Presser foot timing

Set the timing of moving down the presser foot by all needles in a batch or by needle bar unit.

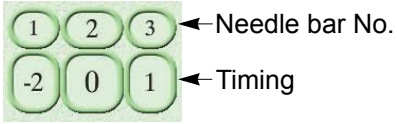
- If the setting of Presser foot timing has been changed by “Needle bar setting” individually, the value of “Needle bar setting” will take priority.

Setting range

“Any” (all needles in a batch): -20 to 20



“Needle bar unit”: -20 to 20



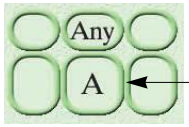
19. Presser foot stroke mode

Set the height of the presser foot stroke by all needles in a batch or by needle bar unit.

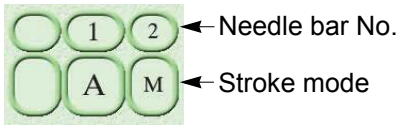
- If the setting of Presser foot stroke mode has been changed by “Needle bar setting” individually, the value of “Needle bar setting” will take priority.

Setting range

“Any” (all needles in a batch): A(Auto)/M(Manual)



“Needle bar unit”: A (Auto)/M(Manual)



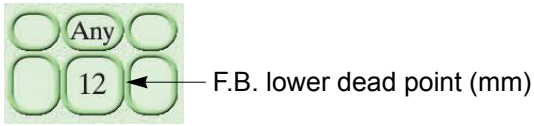
20. Presser foot F.B. lower dead point

Set the height of the lower dead point of the presser foot by all needles in a batch or by needle bar unit when performing Frame Back.

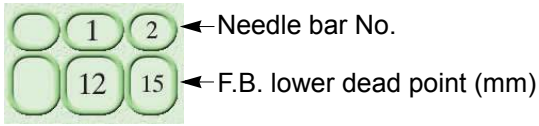
- If the setting of Presser Foot F.B. lower dead point has been changed by “Needle bar setting” individually, the value of “Needle bar setting” will take priority.

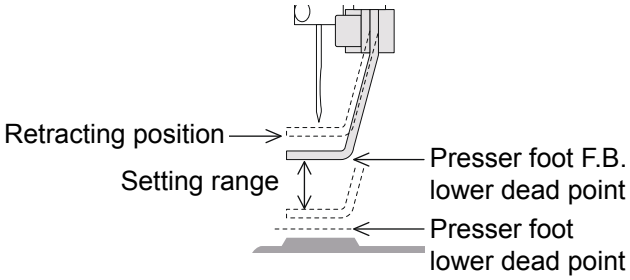
Setting range

“Any” (all needles in a batch): 5.0 to 22.0 mm, R. (retracting position)



“Needle bar unit”: 5.0 to 22.0 mm, R. (retracting position)





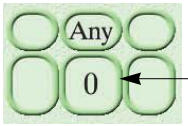
Chapter 4
Parameter Items (Page P3)

21. Thread trim length

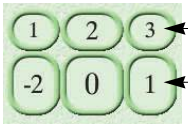
Adjust the remaining length of the upper thread after thread trimming by all needles in a batch or by needle bar unit.

Setting range

“Any” (all needles in a batch): -2 to 2



“Needle bar unit”: -2 to 2



[Setting value]

Remaining length

-2 ◄——► 2

Short Long

23. Return stitch

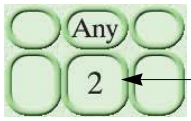
Set the number of Return stitch and stitch length performed at start of embroidery by all needles in a batch or by needle bar unit.

- If the setting of Sewing start return stitch has been changed by “Needle bar setting” individually, the value of “Needle bar setting” will take priority.

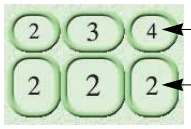
Setting range

■ [Return stitches]

“Any” (all needles in a batch): No. 1, 2, T0, T1, T2



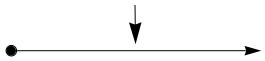
“Needle bar unit”: No. 1, 2, T0, T1, T2



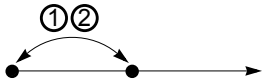
[Setting value]

“No”: No return stitches

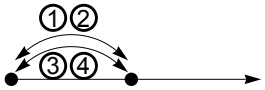
Stitch at start of sewing



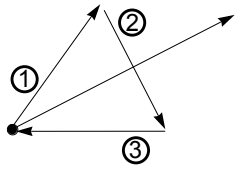
1: One reciprocation



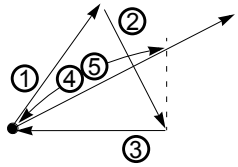
2: Two reciprocations



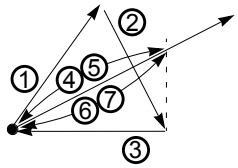
T0: Triangle



T1: Triangle + one reciprocation

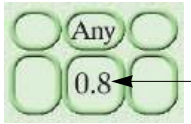


T2: Triangle + two reciprocations

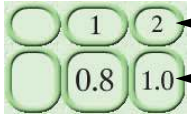


■ [Stitch length]

“Any” (all needles in a batch): 0.6, 0.8, 1.0, 1.2, 1.6, 2.0



“Needle bar unit”: 0.6, 0.8, 1.0, 1.2, 1.6, 2.0



24. Tie Stitch

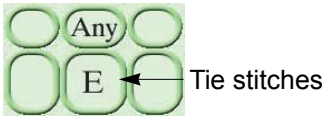
Set Tie stitch pattern and stitch length to be executed before thread trimming by all needles in a batch or by needle bar unit.

- If the setting of Tie Stitches has been changed by “Needle bar setting” individually, the value of “Needle bar setting” will take priority.

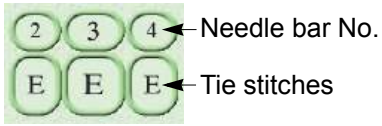
Setting range

■ [Tie stitches]

“Any” (all needles in a batch): No, B, C, D, E, TE



“Needle bar unit”: No, B, C, D, E, TE

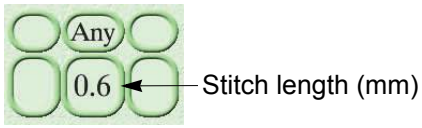


[Setting value]

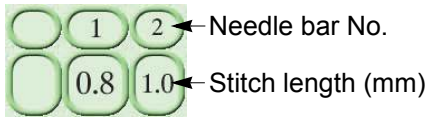
“No”: Not to perform tie stitching
B: Perform tie stitching
C: After embroidering 2 stitches at the same place, tie stitching will be performed.
D: 1 reciprocating to perform tie stitching
E: Switch B and D depending on the direction of tie stitching
TE: Dedicated tie stitching for Multi-cord
(for more information, see the multi-cord device manual)

■ [Stitch length]

“Any” (all needles in a batch): 0.6, 0.8, 1.0, 1.2, 1.6, 2.0



“Needle bar unit”: 0.6, 0.8, 1.0, 1.2, 1.6, 2.0



25. Upper thread lock timing

You can set the upper thread lock timing to adjust the thread tightening at the start of sewing or at the time of thread trimming.

Setting range

[Release] (at the start of sewing): B, C
[Lock] (at the time of thread trimming): A, B, C

[Setting value]

A
B
C ▼ Thread tightening is strong and hard to fray

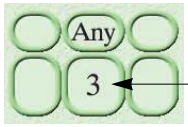
26. Upper thread detection

Set the sensitivity of detection when the upper thread breaks by all needles in a batch or by needle bar unit.

- If the setting of Thread breakage detection has been changed by “Needle bar setting” individually, the value of “Needle bar setting” will take priority.

Setting range

“Any” (all needles in a batch): 0, 1, 2, 3, 4

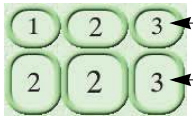


Detecting sensitivity

[Setting value]

Sensitivity
1 ◄——► 4
High Low

“Needle bar unit”: 0, 1, 2, 3, 4



Needle bar No.
Detecting sensitivity

- Thread breakage is not detected if the detecting sensitivity is set to “0”. Therefore, the machine will not stop even if a thread breakage occurs.
- If the detection sensitivity is set to “3”, the machine will stop working when detecting thread breakage three times consecutively.

27. Under thread detection

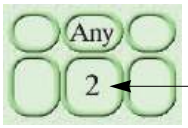
Set the number of consecutive detection times of the “step ratio” (described later) regarded as the the under thread breakage by all needles in a batch or by needle bar unit.

- If the setting of Thread breakage detection has been changed by “Needle bar setting” individually, the value of “Needle bar setting” will take priority.

Setting range

■ [Unit]

“Any” (all needles in a batch): 0, 2, 4, 6, 8



Detecting sensitivity

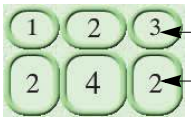
[Setting value]

Sensitivity

2 ◄——► 8

High Low

“Needle bar unit”: 0, 2, 4, 6, 8



Needle bar No.

Detecting sensitivity

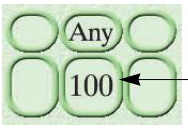
- Thread breakage is not detected if the detecting sensitivity is set to “0”. Therefore, the machine will not stop even if a thread breakage occurs.

Set the detection sensitivity of the under thread breakage by all needles in a batch or by needle bar unit.

Setting range

■ [Step ratio]

“Any” (all needles in a batch): 30, 40, 50, 60, 70, 80, 90, 100



Detection ratio (%)

[Setting value]

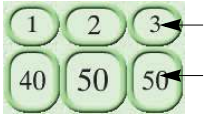
Detection ratio (%)

Sensitivity

30 ◄——► 100

Low High

“Needle bar unit”: 30, 40, 50, 60, 70, 80, 90, 100



Needle bar No.

Detection ratio (%)

28. Upper thread binding at start of emb.

29. Auto origin return

This is the setting to return the frame to the start position after embroidery is completed.

Setting range

“Yes”: Return to the start position.
“No”: Do not return to the start position.

30. Return Frame after Frame Travel

This is the setting to return the frame to the previous position by the start switch operation after moving the frame during embroidery.

Setting range

“Yes”: The frame is returned to previous position.
“No”: The frame is not returned to previous position.

- Selecting “No” will disable “Automatic data point return”. In this case, the frame will not be returned and the machine will start embroidery from the position after frame movement when the switch is operated. For more information on “Automatic data point return”, refer to the separate “Basic Operation” manual.

Chapter 5
Parameter Items (Page P4)

31. Jump Code Combine

This setting combines the travel amounts of consecutive jumps to feed frames at a time. The travel amounts can be combined until a total travel amount of 36.0 mm is reached.

Setting range

”Yes": Jump codes are combined.
”No": Jump codes are not combined.

32. Language

Switch the language display of screen.

33. Preset Halt

1. Preset Halt by Stitches

This is the setting to stop the machine automatically when the number of stitches reaches the setting value.

Setting range

0 to 999,999 (stitches)
After stop, “1D2” will be displayed.

2. Preset Halt by Data

This is the setting to stop the machine automatically when the cumulative amount of frame travel reaches the setting value.

Setting range

0 to 99,999 (cm)
After stop, “1D2” will be displayed.

3. Preset Halt by Designs

This is the setting to stop the machine automatically when the cumulative number of embroidery designs reaches the setting value.

Setting range

0 to 999 (designs)
After stop, “1D2” will be displayed.

4. Preset Halt by Designs

This is the setting to stop the machine automatically when the rotation number of times of the main shaft reaches the setting value.

Setting range

0 to 990,000 (RPM)

- Setting value x 10,000 is the stopping the rotation number of times of the main shaft. After stop, “OIL” will be displayed. It is effective when “9. Automatic lubrication system” on page P7 is set to “No”.

5. Preset halt (1st before end code)

This is the setting to stop the machine automatically at the position one stitch before the embroidering end.

Setting range

“Yes”: Automatic stop is performed.
After stop, “1D2” will be displayed on the operation panel.
“No”: Automatic stop is not performed.

- If “Yes” is selected, it is possible to perform frame back after stop of the machine.

6. Preset halt (ATH clean-up)

This is the setting to stop the machine automatically when the number of ATH used reaches the setting value.

Setting range

500, 1,000, 1,500, 2,000 (times)

39. Optional position

Register the desired frame position.
Move the frame to the arbitrary position using the Frame Travel key and then press the SET key.

Setting range

“Yes”: Register the frame position.
“No”: Do not register the frame position.

- If “Yes” is selected, the X/Y coordinates from frame absolute origin will be displayed.
- For more information on “Arbitrary position”, refer to the separate “Basic Operation” manual.

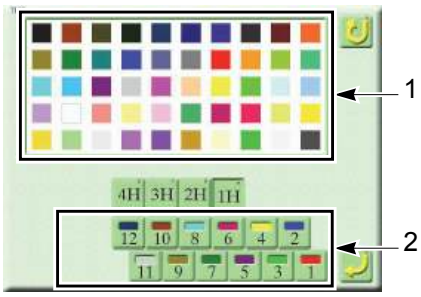
40. Needle Bar Color

Color the design displayed on the screen according to the color of thread to use actually.

Setting range

“Yes”: The color is set to the setting color you used when creating the design in DG by Pulse.
“No”: A color is selected in the palette.

If you select “No”, set the color as follows, using the pallet displayed by pressing .



1. Select a color from the palette.
2. Select the needle bar whose color you want to change.

Chapter 6
Parameter Items (Page P5)

41. Lubrication cycle

Set the cycle (number of stitches) at which the automatic lubrication system will lubricate the rotary hook.

Setting range

1,000, 40,000, 50,000, 60,000, 300,000, 400,000, 500,000 (stitches)

42. Lubrication cycle (head)

Set the cycle (number of stitches) at which the automatic lubrication system will lubricate to the inside of the head.

Setting range

0, 1,000, 300,000, 400,000, 500,000 (stitches)

43. Sequin feed amount (R)

Set sequin feed amount of Sequin Device at the right side.

Setting range

Sequin device III: 3.0 to 9.9 mm/in 0.1-mm increments
Sequin device IV: 3.0 to 23.0 mm/in 0.1-mm increments
10.0 to 23.0 mm/in 0.5-mm increments

44. Sequin feed amount (L)

Set sequin feed amount of Sequin Device at the left side.

Setting range

Sequin device III: 3.0 to 9.9 mm/in 0.1-mm increments
Sequin device IV: 3.0 to 23.0 mm/in 0.1-mm increments
10.0 to 23.0 mm/in 0.5-mm increments

45. Auto lifting-Sequin/Beads device

Specify whether or not to raise the sequin device at frame stepping, at thread breakage, or when sequin chip runs out.

Setting range

■ [Frame stepping]
“Yes”: Raise the sequin device to the upper dead point at the time of frame stepping.
“No”: Do not raise the sequin device to the upper dead point at the time of frame stepping.

■ [Thread breakage]
“Yes”: Raise the sequin device to the upper dead point at the time of thread breakage.
“No”: Do not raise the sequin device to the upper dead point at the time of thread breakage.

■ [Running out of material]
“Yes”: Raise the sequin device to the middle point when sequin runs out.
“No”: Do not raise sequin device when sequin runs out.

48. Multi Cord Setting

1. Auto Stop

This setting automatically stops the machine after sewing a specified number of stitches to cut extra cord generated when you start sewing cord.

Setting range

“No”: Do not halt.
“Any” (All needles in a batch): 5, 10, 15, 20, 25, 30
[Needle bar unit]: 5, 10, 15, 20, 25, 30

2. Cord threading position

Set the height at which to pass the cord through the cord presser.

Setting range

10.0 to 22.0 (mm)

3. Cord cutting position

Set the height of the cord presser at which the cord cut device should cut the cord.

Setting range

1.0 to 9.5 (mm)

4. Cord cut waiting position

Set the height of the cord presser at which the cord presser should wait until cutting the cord when the cord cut device is not equipped.

Setting range

10.0 to 22.0 (mm)

50. Detailed Network information

It is possible to check the setting state of Network.

Chapter 7
Parameter Items (Page P6)

51. User customization

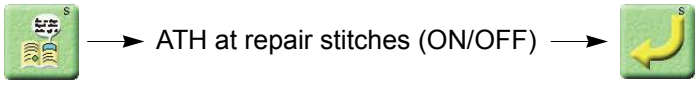
This setting allows you to assign specific functions to the G1 and H2 switches of the tension base.
For details, refer to the separate “Basic Operation” manual.

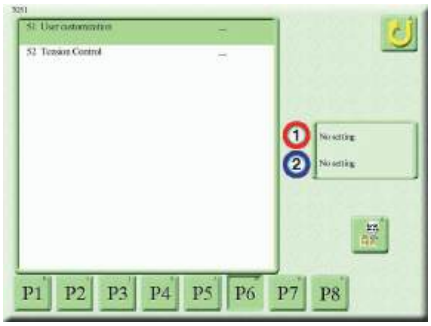
Setting range

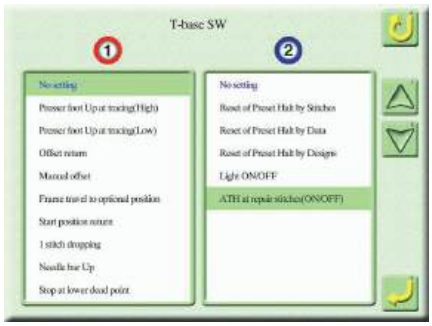
G1 switch
Without setting, 1 stitch dropping, Presser foot Up at tracing (High), Presser foot Up at tracing (Low), Offset return, Manual offset, Frame travel to an optional position, Return to the start position, Raising of needle bar, Stop at Lower D. Point

H2 switch
Without setting, Reset of Preset Half (Stitch), Reset of Preset Half (Data), Reset of Preset Half (Design), Light ON/OFF, Thread trimming at the time of repair stitches (ON/OFF)

Example: Assigning “Thread trimming at the time of repair stitches (ON/OFF)” to the H2 switch.







52. Tension Control

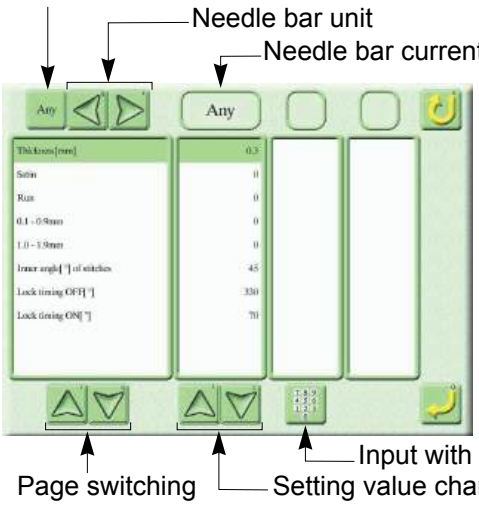
1. Setting Initial Value

Set to make the initial value of i-TM by all needle bars in a batch or by needle bar unit.

Setting range

Press to display the initial values of i-TM.

- Keep the setting values other than Thickness, Satin, and Run unchanged. If you need to change them, consult the distributor.



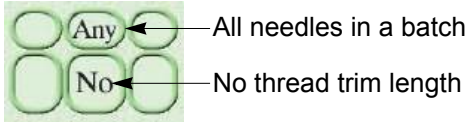
"Thickness (mm)": Fabric thickness 0.0 to 8.0
"Satin": Satin stitch -20 to 20
"Run": Running stitch -20 to 20
"0.1 to 0.9 (mm)": Fine stitch
"1.0 to 1.9 (mm)": Small stitch
"Inner angle of stitches (°)": 0 to 180
"Lock timing OFF (°)": 330 to 10
"Lock timing ON (°)": 70 to 105

2. Thread trim length adjusting operation

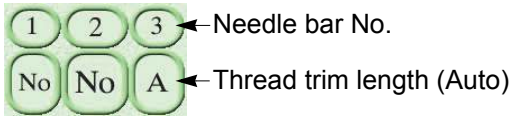
Set to make the initial value of i-TM by all needle bars in a batch or by needle bar unit.

Setting range

"Any (all needles in a batch)": No (Not to perform), A (Auto)



"Needle bar unit": No (Not to perform), A (Auto)



4. i-TM mode

Select Auto/Manual for i-TM mode.
The i-TM icon on the main screen will change with this setting.

Setting range

"Auto" : Automatically adjust each i-TM parameter.
"Manual" : Manually adjust each i-TM parameter.

- No "Presser foot lower dead point" settings for the parameter, the manual operation and the needle bar settings are available while in "Auto mode".
- You cannot change the i-TM mode during sewing.

53. General external device

1. Automatic moving up of seed beads device

Specify whether or not to raise the seed beads device at frame stepping.

Setting range

■ [frame stepping]
“Yes”: Device is raised at frame stepping.
“No”: Device is not raised at frame stepping.

Chapter 8
Parameter Items (Page P7)

To display page P7, you must enter the password and change the functional limit level.

71. R.P.M. setting

2. Low Speed / L.S. code R.P.M.

Set the embroidery speed (low speed R.P.M.) decreased by stitch length and the embroidery speed (Low speed code R.P.M.) in the low speed code section.

Setting range

“Low speed r.p.m.”: 250 to 600 (rpm)
“Low speed code r.p.m.”: 250 to maximum r.p.m. of machine

3. Start/ATH inching r.p.m.

“Start inching r.p.m.”
Set the number of start inching r.p.m. after data setting, thread trimming, and stopping the machine during embroidery.
“ATH Inching r.p.m.”
Set ATH inching r.p.m. before thread breakage.

Setting range

“Start inching r.p.m.”: 100, 150, 200, 250 (rpm)
“ATH Inching r.p.m.”: 120 (rpm)

72. Stitch compensation

1. Backlash (X)

Correct driving error of the frame generated when a stitch turns back in horizontal direction.

Setting range

-0.5 to +0.5 (mm)

- If the value is input, the setting of Satin stitch will be invalid.

2. Backlash (Y)

Correct driving error of the frame generated when a stitch turns back in vertical direction.

Setting range

-0.5 to +0.5 (mm)

- If the value is input, the setting of Satin stitch will be invalid.

3. Satin stitch (area)

Set a target range of Satin Stitch (Expansion).

Setting range

“Whole”: All Satin stitches in design
“Part”: Function code “Satin stitch” section
“No”: Do not add.

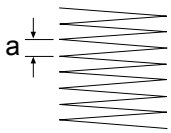
- If the setting of Satin stitch (area) has been changed by “Needle bar setting” individually, the value of “Needle bar setting” will take priority.

4. Satin stitch (density)

Set stitch length (a in the figure below) that is regarded as Satin stitch. Stitches of the setting value or less will be regarded as Satin stitch.
It is effective when “3. Satin stitch (area)” is set to “Whole” or “Part”.

Setting range

0.4 to 1.0 (mm)



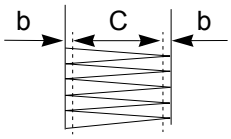
- If the setting of Satin stitch (density) has been changed by “Needle bar setting” individually, the value of “Needle bar setting” will take priority.

5. Satin stitch (Expansion)

This setting sets up an adding amount to a stitch that was judged as Satin stitch in above “4 Satin stitch (density)”. 1/2 (b) of the set value will be added to both sides of the stitch (c) respectively.

Setting range

-1.0 to +1.0 (mm)



- If the setting of Satin stitch (Expansion) has been changed by “Needle bar setting” individually, the value of “Needle bar setting” will take priority.

73. Design Setting

2. Condition data

When you register the design saved in the USB memory into the machine memory, set whether the condition data (Color change sequence, Start position) are registered together with the design into the machine memory or not.

Setting range

“Yes”: It will be registered into the machine memory
“No”: It will not be registered into the machine memory.

3. Automatic design rotation (180 deg.)

The design will be embroidered with 180° rotation automatically if you use the specified frame.

Setting range

“Yes”: 180° rotation (Frame specified, “ALL” specifies all frames)
“No”: Not to rotate

4. Presser Foot Up at Tracing

At the time of tracing, specify whether or not to raise the presser foot.

Setting range

“Yes”: Raise the presser foot.
“No”: Do not raise the presser foot.

74. Frame setting

1. Software frame limit

Set to make to stop the frame at the limit position where the frame can move set by the frame type.

Setting range

“Yes”: To stop
“No”: Not to stop

2. Frame Type

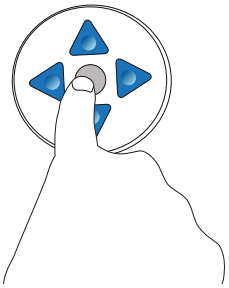
⚠Caution

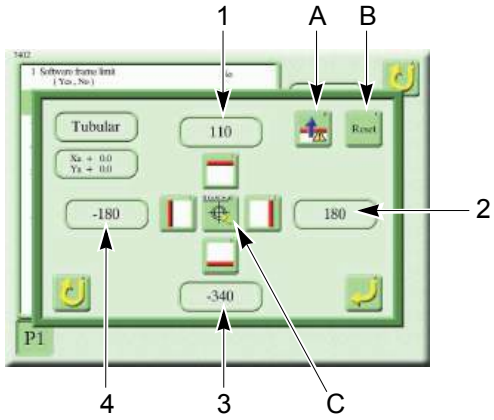
Do not put your hands or other parts of your body around the frame. You may injure your fingers, hands, etc. as you move the frame when setting the soft frame limit range.

Set the software frame limit range (rear, front, left, right) of the frame being used.

Setting range

Varies with each frame type.





Press to execute absolute origin search (at which time, the frame will move).

↓

Using the frame travel key, move the frame to the limit position.

↓

(Rear), (Front), (Left), (Right)

When the switch is pressed, the current frame coordinates are displayed in the limit display field and set as the limit position.

↓

Press to register each position.

To exit from the setting mode, press .

1. Limit display on the rear side
2. Limit display on the right
3. Limit display on the front side
4. Limit display on the left side

A. Release of software frame limit
The frame moves beyond the position of the software frame limit.

B. Reset
The position is reset to the limit position according to the frame size.

C. Absolute origin search
Execute absolute origin search.

3. Frame weight

Adjust the frame weight according to the type of fabric.

Setting range

0, 5, 10, 15, 20 (kg)

4. F. Travel Speed / Stepping Method

Set the frame travel speed and the frame stepping method at frame stepping.

Setting range

“Frame Travel Speed”: 100, 200 (mm/second)
“Frame Stepping Method”: Batch, 1 stitch
Batch: Perform frame travel directly to frame stepping point.
By 1 stitch: Perform frame travel stitch by stitch as design data.

5. Frame start timing

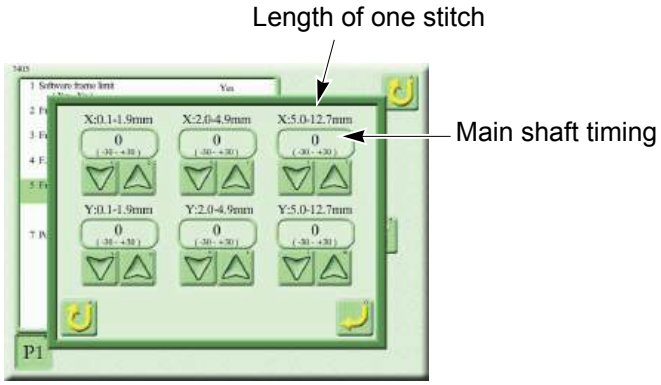
⚠Caution

To change this value, consult the distributor. Under certain operating conditions, changing the value may adversely affect the sewing performance.

Set the main shaft timing where the frame starts moving.

Setting range

-30 to +30: Frame start timing



[Setting value]

-30 ← Fast
+30 → Slow

Thread tightening: loose
Thread tightening: strong
Stitch length: short

6. Frame start timing (FS mode)

In FS mode, set the main shaft timing where the frame starts moving.

Setting range

-20, 0: Frame start timing

- Set the frame start timing to “-20” in FS mode.

7. Power Resume with the power-ON

Set whether or not absolute origin search is performed when the power in turned ON.

Setting range

“Yes”: Absolute origin search is executed.
“Before sewing”: Absolute origin search is not executed during sewing.
“No”: Absolute origin search is not executed.

75. ATH setting

1. ATH

This is the setting to trim the thread automatically at Color change, Frame stepping and Offset frame travel.

Setting range

“Yes”: ATH is performed automatically.
“No”: ATH is not performed automatically.

5. ATH at repair stitches

Set whether or not to perform thread trimming at repair stitches.

Setting range

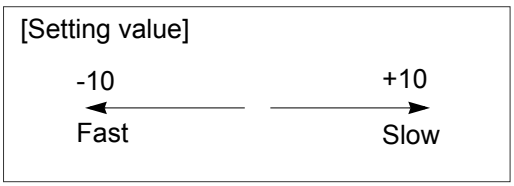
“Yes”: ATH is performed.
“No”: ATH is not performed.

6. ATH Start Timing

Set the timing of the knife starts moving.

Setting range

-10 to 10: Knife start timing



76. Stop position

1. Stop at Lower Dead Point

This is the setting to stop (Stop at lower dead point) the machine at end of embroidery with the needle stuck.

Setting range

“Yes”: Stop at Lower Dead Point is performed.
“No”: Stop at Lower Dead Point is not performed.

2. Return Frame at Lower dead point

This is the setting to return the frame by manual offset even after frame travel during Stop at Lower Dead Point.

Setting range

“Yes”: The frame is returned by manual offset.
“No”: The frame is returned by manual offset.
However, it will not return by the amount of frame moving during stop at lower dead point.

77. Optional device (Hardware)

1. Sequin device (R)

Set whether or not Sequin device will be equipped on the right side and the type of device.

Setting range

“ESQ-C”: ESQ-C
“SQ4”: Sequin device IV
“No”: Without sequin device

2. Sequin device (L)

Set whether or not Sequin device will be equipped on the left side and the type of device.

Setting range

“ESQ-C”: ESQ-C
“SQ4”: Sequin device IV
“No”: Without sequin device

3. Insertion of jump at sequin

This is the setting to insert one stitch of non-data jump code just before or after sequin feed.

Setting range

[After output]
“Yes”: Insert a non-data jump code just after sequin feed.
“No”: Do not insert a non-data jump code.
[Before output Y>0] (Displayed in the case of ESQ-C)
“Yes”: Insert a non-data jump code before sequin feed.
“No”: Do not insert a non-data jump code.

6. Multi Cord Device

Select whether or not to equip the multi-cord device.

Setting range

“MCD1”: Multi Cord Device
“MCD2”: Multi Cord Device 2
“MCD2+CC”: Multi Cord Device 2 and Cord cutting device
“No”: Multi Cord device is not equipped.

8. Air pressure confirmation switch

Set whether or not to equip Air pressure confirmation switch.

Setting range

“Yes”: Air pressure confirmation switch is equipped.
“No”: Air pressure confirmation switch is not equipped.

- In this function, when an option that needs compressed air is equipped, select “Yes” (Example: Sequin device IV, etc.).

9. Automatic lubrication system

Set whether or not to equip Automatic lubrication system and the type of the device.

Setting range

“Yes”: Automatic lubrication system is equipped.
With valve (LB1 for head and rotary hook.)
Without valve (LB2 for head)
“No”: Automatic lubrication system is not equipped.

12. LED lamp

Set whether or not to equip LED light.

Setting range

“Yes”: LED light is equipped.
“No”: LED light is not equipped.

18. Seed Beads Device

Select whether or not to equip the seed beads device.

Setting range

“No”: Seed beads device is not equipped.
“L”: Seed beads device is equipped on the left side.
“R”: Seed beads device is equipped on the right side.
“LR”: Seed beads devices are equipped on the right and left sides.

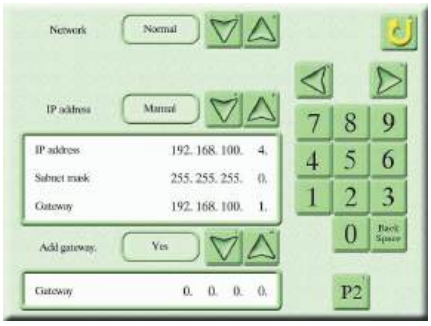
78. Optional device (software)

1. Network

Set whether or not to perform network connection with DG by Pulse and IP address, etc.

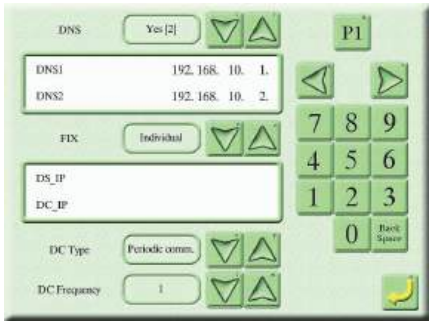
Setting range

“Page P1”



“Normal”: Connect to DG
“Auto-Load”: Auto loading from DG
“No”: Not to connect.
“IP address”
Auto: IP address will be obtained from DHCP server.
Manual: Set following items manually without using DHCP server.
IP address
Subnet mask
Gateway
“Add gateway”
“Yes”: Add gateway.
“No”: Do not add gateway.

“Page P2”



“DNS”
Yes “1”: IP address of DNS1 server
Yes “2”: IP address of DNS2 server
“No”: None
“FIX”
Automatic: Search IP address of the host PC side automatically.
Manual: Set IP address of the host PC side manually.
Individual: Set IP address of the host PC side individually.
“DS_IP”
Input the IP address of the host PC used as Design Spooler to “DS_IP”.
Available for use in conjunction with DG by Pulse or later version.
“DC_IP”
Input the IP address of the host PC used as Data Collector to “DC_IP”.
Available for use in conjunction with DG by Pulse or later version.
“DC Type”
Select information transmitting method to Data Collector
No transmission.
Periodic comm.: Communicating periodically
Event comm.: Transmitting at the start and the stop of operation only
“DC Frequency”
Select information transmitting frequency (time interval)
1 to 999,999/1 (per second)

2. Network name

Set Network name.

Chapter 9
Parameter Items (Page P8)

To display page P8, you must enter the password and change the functional limit level.

84. Functional limit

1. Password (functional limit)

Change the password. Select the password from 4 to 8 digits alphanumeric characters.

- For details of the password, consult the distributor.

2. Functional limit level

Change the operation level (1, 2, SEL). The operation level restricts access to operations.

Setting range

1, 2, SEL

- For details of the password, consult the distributor.

3. Password (time limit)

Enter the password to cancel the time limit function.

- For details of password settings, consult the distributor.

85. Machine adjustment

1. Date and time

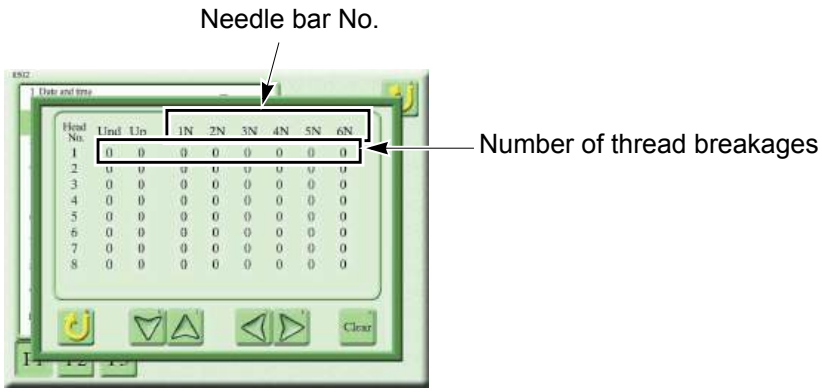
Set date and time.

Setting range

Year, month, day, time, minute, 00 second

2. Total number of thread breakage

Display the number of thread breakage of upper thread/under thread by head unit.



3. Error stack

Display errors that have ever occurred and time of occurrence.

- The error to be occurred last is No.1.

4. Memory process

Deal the data in the machine memory.

⚠Caution

If “Memory initialize” is executed, the design data, general setting data and the setting value of “86. Machine condition” will be deleted.

Setting range

“Backup”

: Store the machine setting data *1 into USB memory.

- Insert USB memory into the operation panel before operation.

: Store the machine setting data *1 into the operation panel.

- You can select USB memory, operation panel, or both.

“Initialization (Parameter)”
Reset the parameter settings and error stack to the factory defaults.

“Initialization (Memory)”
Delete the design and setting data value. To reconfigure the settings after this operation, refer to the “Parameter setting chart” attached to the machine at shipment.

“Writing”

: Write the setting data backed up in the USB memory into the machine memory.

- Insert USB memory into the operation panel before operation.

: Write the setting data backed up in the operation panel into the machine memory.

*1 Setting data:Parameter setting value, error stack and machine log data download

6. Display of main shaft stop position

It displays whether the current main shaft angle is within the range of fixed position or not.

: Within fixed position

: Out of fixed position, or Stop at Lower Dead Point

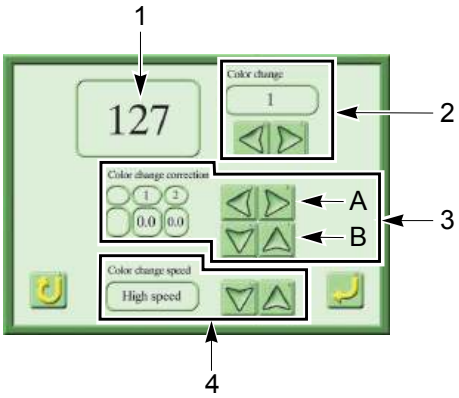
7. Display of needle position angle

Correct the deviation of each needle locating position with the potentiometer value at the time of color change.

⚠Caution

Do not put your hands etc. near needle bar case. The needle bar case moves with pressed, which may result in finger or hand injury.

Press to display the potentiometer value.



1. Value of potentiometer of needle bar selected currently
   It is normal when the value at the first needle is “127”.
2. Needle bar No.
   Switch the needle bar.
3. Correction of color change
   Offset the frame per needle bar.
   A. Select the needle bar
   B. Change in correcting value: 5 to -5 (mm)
4. Switching color change speed
   Switch between High speed and Low speed.

8. Time for detect power failure

Set the machine movement when the power is shut off momentarily.

Setting range

“Short”
When the power is shut off momentarily, the machine will stop at the fixed position.

“Long”
It is possible to embroider without stopping the machine even if the power is shut off in longer time than [Short]. However, when the power is shut off during some period of time, the machine will stop. In this case, the design in the middle of embroidery cannot be guaranteed.

9. Main Shaft Brake

This is the setting to apply/not to apply the brake of Main shaft motor at stop of the machine.

Setting range

“Yes”: Apply the brake. (Fixing main shaft)
“No”: Do not apply the brake. (Release of fixing main shaft)

- If “No” is selected, it is possible to turn the main shaft by hand with the power ON.

10. Frame servo lock

This setting selects to lock/not to lock X/Y-axis motor.

Setting range

“Yes”: Lock X/Y-axis motor.
“No”: Unlock X/Y-axis motor

- X/Y-axis motor will not operate when set to “No”. Therefore, it will become impossible to embroider.

12. Manual frame travel speed

Perform fine adjustment of Frame travel speed when you move the frame manually.

Setting range

“Middle speed”: 30 to 70 (mm/sec)
“High speed”: 80 to 150 (mm/sec)

13. Automatic frame travel speed

Perform fine adjustment of frame travel speed at offset frame travel.

Setting range

100: 80 to 150 (mm/sec)
200: 180 to 220 (mm/sec)

- The value here will be reflected in “4. F. Travel speed” on page P7.

14. Frame weight data install

Perform the additional installation of frame weight data.

- Set the USB memory in which frame weight data is saved and execute it. For details, consult the distributor.

15. Software install

Upgrade the software version.
Refer to the separate “Advanced Operation” manual.

17. Sequin chip feed

This operation feeds forward sequin tips one by one using the tension base switch.
It is possible to operate only when the needle bar equipped with Sequin device is selected.

(Chip Feed)

Every time you press it, a sequin chip is fed.

Exit from the feed mode.

For adjusting the sequin color change sensor

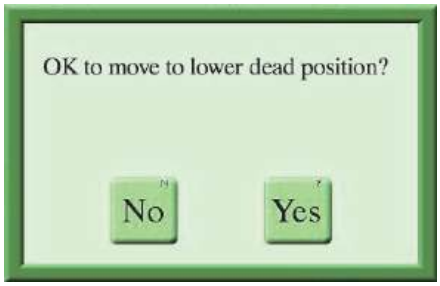
(Search Sensor)

The sequin color change motor is excited. Use it for adjusting the sensor position.

Exits from the sensor mode.

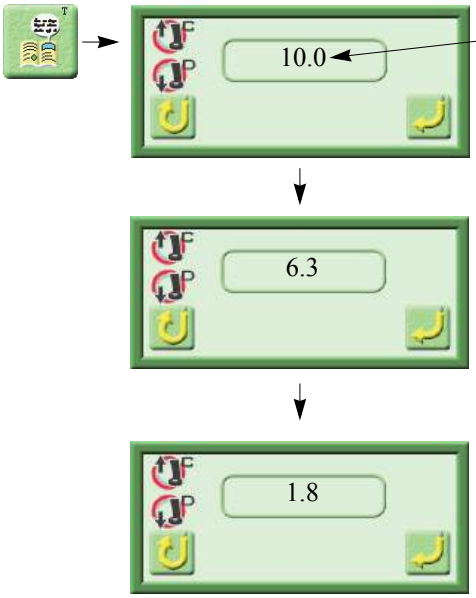
For adjusting the sequin cut position.

(Presser Foot)



18. Presser foot lower dead point adjustment

Visually adjust the presser foot lower dead point. This setting value is also applied to all needles.



Display the presser foot height (mm)

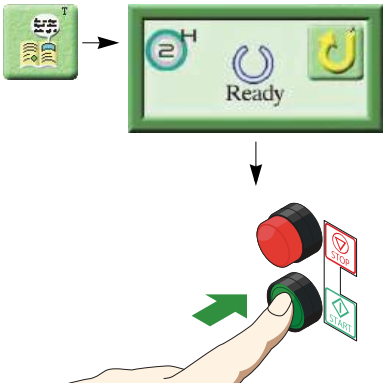
When D switch is pressed, the presser foot will stop at the upper limit of the setting range.

Press D switch and visually adjust the lower dead point.

Press to make settings, and to exit after the setting is finished, press .

19. Presser foot installation

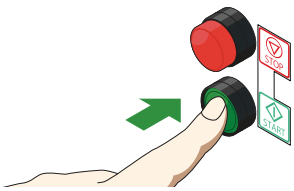
Use the provided presser foot gauge and reset the presser foot to the factory-set correct height.



When the start switch is pressed, the presser foot will be lowered to the mounting height (5.0 mm). Loosen the screw of the presser foot and put the provided presser foot gauge on the needle plate. Tighten the screw with the presser foot in contact with the presser foot gauge. When adjusting the height of the next presser foot, press the start switch. The needle bar case will slide to the next needle bar, and the presser foot will be lowered to the mounting height.

20. Needle bar upper dead point adjustment

When the start switch is pressed, the needle bars will stop at the upper dead point (0°) in sequence.



When the start switch is pressed, the needle bar case will slide to the next needle bar and the needle bar will stop at the upper dead point.

Make upper dead point adjustments for the needle bar.

When the start switch is pressed while the needle bar is at the upper dead point, the needle bar will return to the original height, and the needle bar case will slide to the next needle bar and the needle bar will stop at the upper dead point.
When the start switch is pressed at the last needle, the needle bar case will slide to the first needle and the needle bar will stop at the upper dead point.

To exit from the setting mode, press .

21. Air lifter adjustment

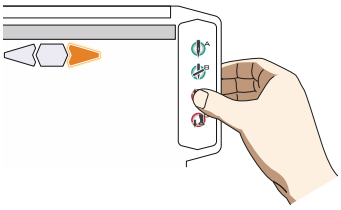
You can raise or lower the Sequin device IV and seed beads device with on the tension base.

When in the adjusting mode, you can raise or lower the devices for all the heads by pressing .

To exit from the adjusting mode, press .

24. Cord cutting device adjustment

You can use the tension base switch to operate the cord cut device step by step.



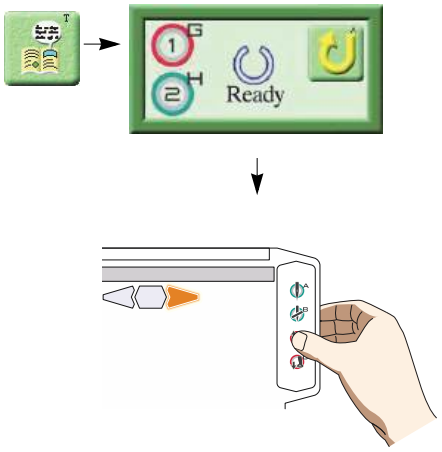
Switch	Operation
A	Return to the retracting position
C	Raise the presser foot (to the retracting position)
D	Lower the presser foot (to the cut position)
G	Raise the cut unit
H	Lower the cut unit

To exit from the setting mode, press

- For information on the operating steps, refer to the “Multi Cording Device 2” manual.

26. i-TM small take-up lever check

Adjust the position of the i-lever if the i-lever interferes with the take up lever guide.



Switch	Operation
1 G	Move up the i-lever.
2 H	Move down the i-lever.

To exit from the setting mode, press .

- For the series of operations, refer to the “i-TM Setup” manual.

86. Machine condition

⚠Caution

Do not change the following parameters from the factory defaults. Doing so could adversely affect the machine operation.

1. Machine number, type
2. Head Interval
3. Y-axis Frame Size
4. Frame Spec
5. Overlap
6. Maximum RPM

2. X-axis embroidery space

Set the X-axis embroidery space.

Setting range

360, 500 (mm)

3. Y-axis frame size

Set the Y-axis embroidery space.

Setting range

450

4. Frame spec

Set the frame specification.

Setting range

S

5. Overlap

Set the overlap width between heads.

Setting range

0

6. Maximum RPM

Set the Maximum RPM.

Setting range

250~1100 rpm/50

11. Frame weight level

Set the frame weight level.

- The data of stitch length adjusted by frame weight level will be registered.
- For details of the frame weight level, consult the distributor.

Setting range

Varies with each frame type.
Border frame B101 2
Tubular goods frame T101 2
Tubular goods frame T201 2
Cap frame C101 2
The frame weight level above differs depending on the model specifications.

12. Available head setting

This setting detaches problematic heads so that you can continue embroidery with other heads.

Setting range

"ALL": Select all heads.
"OFF": Detach selected heads
"ON": Make selected heads ready for embroidery

13. X Stitch Length Adjustment

Perform fine adjustment of stitch length according to its length.

Setting range

1 to 12: Applicable stitch
-60 to +60: Amplitude

Applicable Stitch
Amplitude

[Stitch lengths corresponding to the setting values 1 to 12]

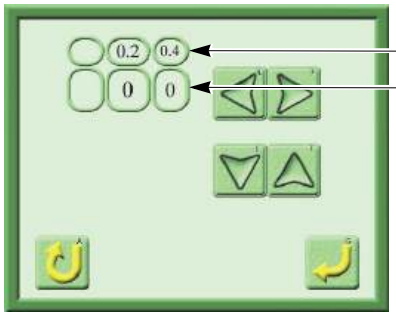
1	2	3	4	…	12
0.0 to 1.8 (mm)	1.9, 2.0 (mm)	2.1 to 3.0 (mm)	3.1 to 4.0 (mm)		11.1 to 12.7 (mm)

-60 Decr ← 0 Amplitude → +60 Incre

- Even after you select one of the setting values 2 to 12, pressing selects the setting value 1.

The setting value 1 applies to a wide range of stitches. So press and fine-tune the amplitude of each stitch length on the following screen. Once you change the amplitude, "---" appears in the amplitude field in the figure above.

[Detailed setting screen for setting value 1]



Stitch length (mm)
Amplitude (-60 to +60)

14. Y Stitch Length Adjustment

Perform fine adjustment of stitch length according to its length.
Refer to "13. X Stitch Length Adjustment".

15. X Stitch Length Adjustment (FS mode)

In FS mode, perform fine adjustment of stitch length according to its length.

Setting range

1 to 12: Applicable stitch
-60 to +60: Amplitude

[Stitch lengths corresponding to the setting values 1 to 12]

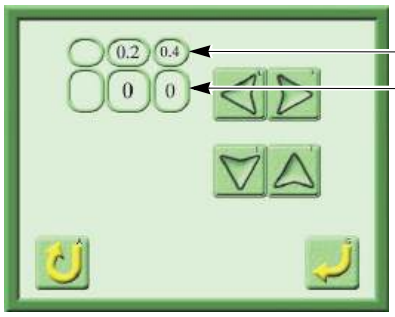
1	2	3	4	…	12
0.0 to 1.8 (mm)	1.9, 2.0 (mm)	2.1 to 3.0 (mm)	3.1 to 4.0 (mm)		11.1 to 12.7 (mm)

-60 Decr ← 0 Amplitude → +60 Incre

- Even after you select one of the setting values 2 to 12, pressing selects the setting value 1.
- Available only in the FS mode.

The setting value 1 applies to a wide range of stitches. So press and fine-tune the amplitude of each stitch length on the following screen. Once you change the amplitude, "---" appears in the amplitude field in the figure above.

[Detailed setting screen for setting value 1]



16. Y Stitch Length Adjustment (FS mode)

In FS mode, perform fine adjustment of stitch length according to its length.
Refer to "14. X Stitch Length Adjustment (FS mode)".

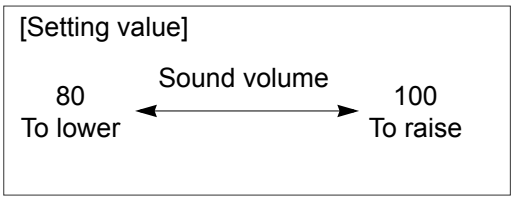
87. Panel setting

1. Sound volume

Adjust a sound volume of a buzzer.

Setting range

80 to 100 (%)



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